

Date
UserMonday, 2/4/2008 11:22:52 AM
Kim Johnston

Process Sheet

Split 108020

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BATTERY LOCK ASSEMBLY
 Job Number : 37148 -2
 Estimate Number : 10900
 P.O. Number :
 This Issue : 2/4/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 36070
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 05-11-22 JLM

Part Number : D3393041
 Drawing Number : D3393 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 2/20/2008 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D27287

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2728-7	Decal	B22554

AS 08/02/19 (X20)

2.0

D33731

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3373-1	Cam Lock	B23643

AS 08/02/19 (X20)

3.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	5/16WC	SS Flat Washer	106731

AS 08/02/19 (X20)

4.0

D33931

Battery Lock Casing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3393-1	Battery Lock Casing	37149

AS 08/02/19 (X20)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 37148

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D33933

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

37150

AS 08/02/19 (XPC)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

SB 08/02/19 (20)

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

SB 08/02/19

ARN/A262 Locktite

M107045

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

SB 08/02/20

Key Numbers

1- A420

5- A420

9 A420

13 A420

17 A420

2- A420

6- A420

10 A420

14 A420

18 A420

3- A420

7- A420

11 A420

15 A420

19 A420

4- A420

8- A420

12 A420

16 A420

20 A420

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

AR N/A SS Rod M10524

PD 08-01-01 (2)

PD 08-05-08 (2)

FC 08/02/20 (20)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 37148

Part Number: D3393041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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8.0

QC9

VISUAL WELDING INSPECTION

QCP



S 08/07/01



08/05/08 (2)

Comment: VISUAL WELDING INSPECTION

PD 08-02-20 (20)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



08/06/08

Comment: SMALL & MEDIUM FAB RESOURCE 1

Apply Crazy Glue to cap and press into Body

9567K21 Batch:

M17089 (2x)

M19102 8B

M19102 (384)

08/07/01 (20)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/01 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C420A

ST 481

PC 8/7/2 (2)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



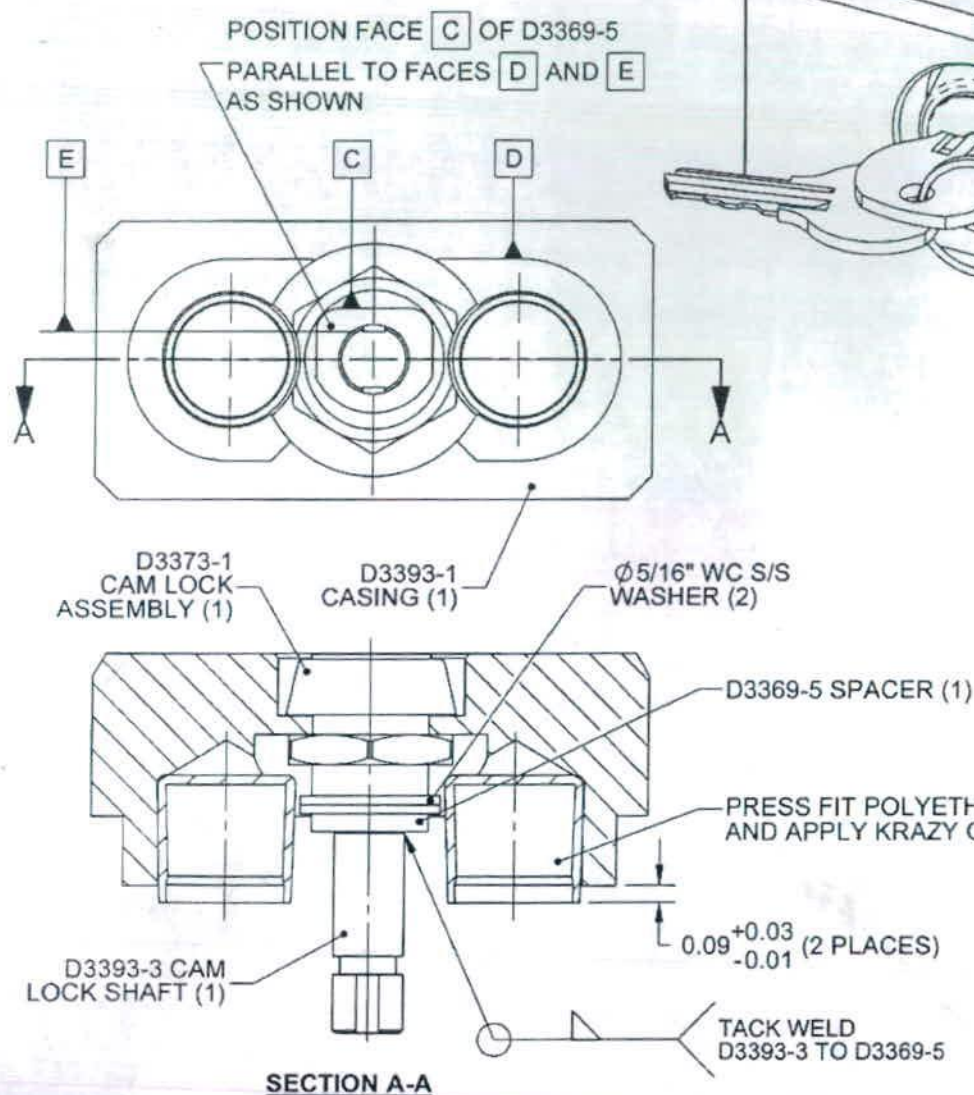
MF 08-07-02

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

05/03/09

D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMaster-CARR, P/N 9567K21

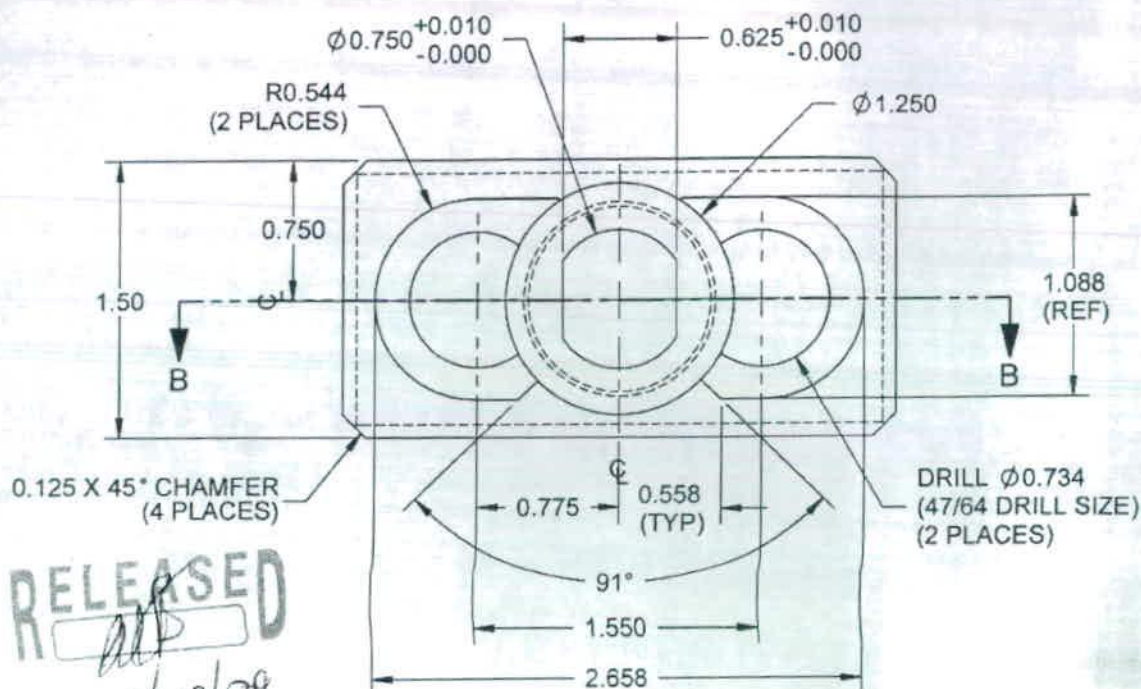
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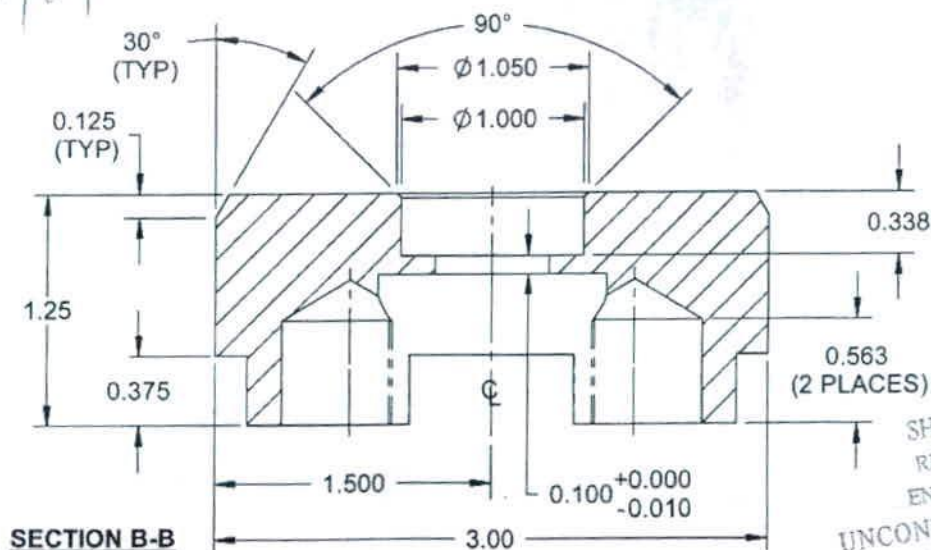
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NO. **37148**

DART

DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 1:1



RELEASED
05/03/09

**D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

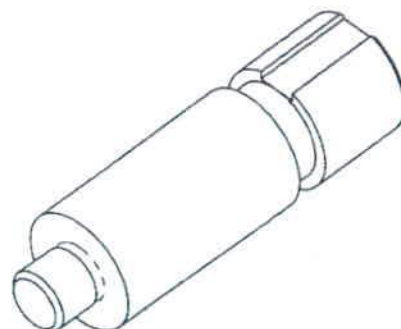
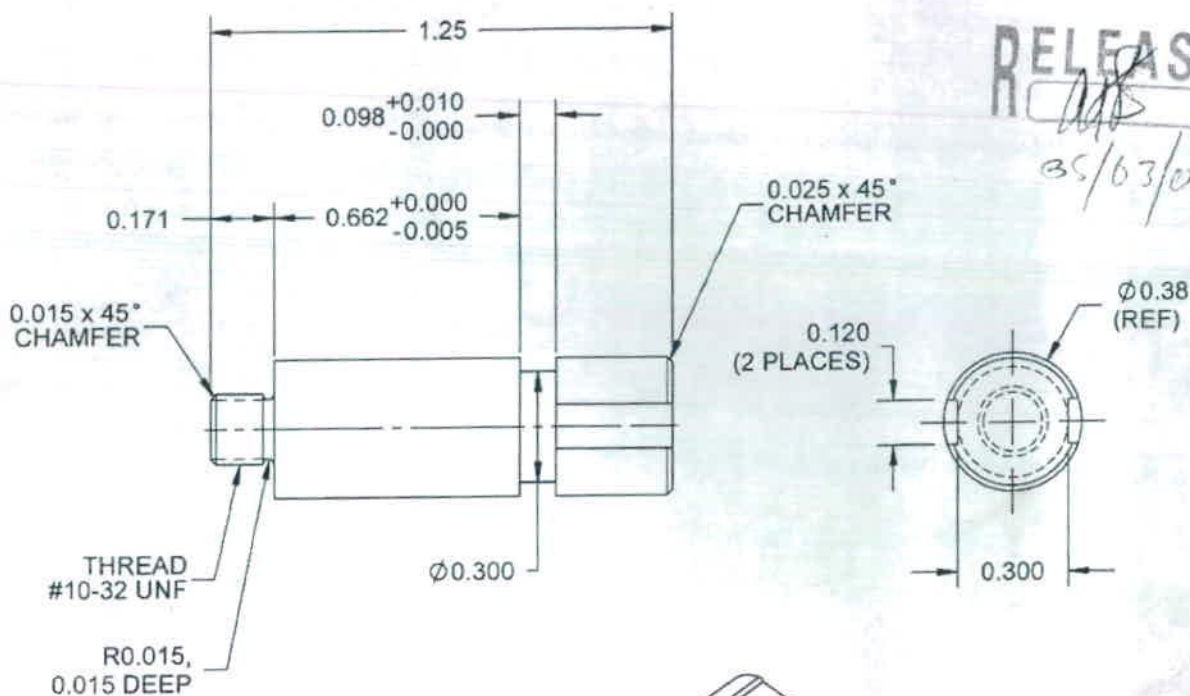
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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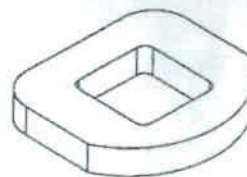
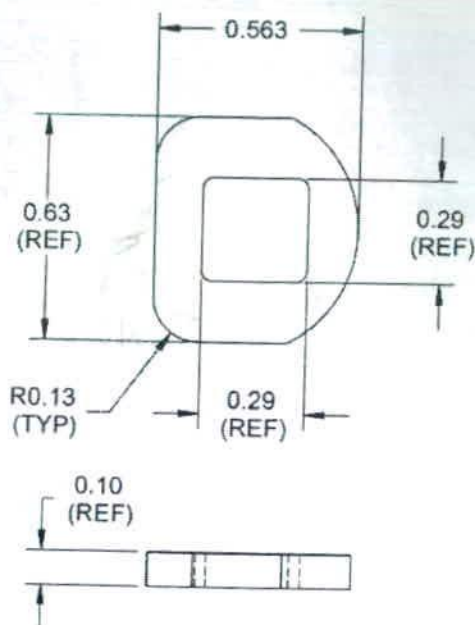
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A
DATE 04.12.16		TITLE BATTERY LOCK	SHEET 4 OF 4 SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11

37148

-5
D3369 SPACER

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0802-20	10.0	w/o split for Qty 2 on this w/o. see NCR below. Qty 18 on -1 w/o.	<i>[Signature]</i>	0802-20	2	<i>[Signature]</i>	<i>[Signature]</i>

Part No: D3393-041 PAR #: N/A Fault Category: Prod/Eng. large NCR: Yes No DQA: D Date: 08/07/03
 QA: N/C Closed: D Date: 08/07/03

NCR: <u>37148</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0802-20	10.0	The D3393-3 cam was crooked after welding. it does not go into the receptacle on Qty 2 R.C: Human error, shift was not straight when trucked.	<i>[Signature]</i> 08/02/20	remove the lock & replace All center components.	SB 08/02/20	<i>[Signature]</i> 08/07/03	<i>[Signature]</i> 08/02/20	

NOTE: Date & initial all entries

